

86886

July-09-12 9:15:59 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/09/12 **Start Qty:** 6.00 ***6***

Cust Item ID:

Required Date: 7/27/12 **Req'd Qty:** 6.00 ***6***

Customer:

Reference:

Approvals: Process Plan: Date: 12-07-10 Tooling: Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2175	Rev E

100

0.00

100

FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D2175

Dwg Rev: 3

Prog Rev: 6

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAJB

0.00

110

Memo

0.00

QC

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86886

86886

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July-09-12 9:15:59 AM

Item ID: D2175-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Angle LH
Start Date: 7/09/12 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 7/27/12 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	SMP / DAS 12-7-24 / 16 2-89 12/4/24			8			
130 *130* Small Fab Small Fab	Small Fab Memo Debur Stack	0.00 0.00	N/A						
140 *140* Brake NC Brake NC	NC BRAKE Memo Form as per Dwg D2175	0.00 0.00				8			SB 12/07/10

W/O:		WORK ORDER CHANGES					
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Work Order ID 86886

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July-09-12 9:15:59 AM

Item ID: D2175-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Angle LH
 Start Date: 7/09/12 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 7/27/12 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC7-Inspect Chemical Conversion Coat	0.00							
170									
QC	Memo	0.00							
Quality Control									

DAS
16
2/25

8

8 7/12 12-7-24

8a

12/07/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 86886

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July-09-12 9:15:59 AM

Item ID: D2175-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Angle LH

Start Date: 7/09/12

Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/27/12

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Identify as per dwg & Stock Location: *GF*

0.00

180

Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

8x

12/17/30

MCJ 12/07/26

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-09-12 9:15:59 AM

Work Order ID: 86886

Parent Item: D2175-1

Parent Item Name: Angle LH

Start Date: 7/09/12

Required Date: 7/27/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP E04.06.09ReformatKJ/RF
IPP Rev:F 06-04-28 Manufactured on Water Jet JLM
IPP Rev:G As per Rev E 06-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 2024-T3 .063 sheet		Purchased	No			100	sf	239.8900	0.4722	2.9823156	41	8-12-7-25	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT022		239.89							
				119916		67.35							
				121197		172.54							
										121197			

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	86886
Description: Angle		Part Number:	D2175-1/-2
Inspection Dwg: D2175 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.650	+/-0.010	12.650	1		T 1B01	
R0.35	+/-0.030	.35	2		R G,	
2.915	+/-0.010	2.916	2		V 1B02	
50°	+/-0.5°	50°	2			
0.300	+/-0.010	.302	2		V	
1.050 Pitch	+/-0.010	1.049	2		V	
10.500	+/-0.010	10.500	2		T	
11.550	+/-0.010	11.502	2		T	
0.550	+/-0.010	.547	2		V	
0.900	+/-0.010	.902	2		V	
0.063 thick	+/-0.010	.064	2		V	
Grain Direction	N/A		2			
Ø0.128	+0.005/-0.001	.129	2		V	
Ø0.172	+0.005/-0.001	.173	2		V	

Measured by: B	Audited by: SMB DAS	Prototype Approval:	N/A
Date: 12-7-24	Date: 12-7-24 16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.03.23	Dimensions revised per Dwg rev. E	KJ/JLM	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

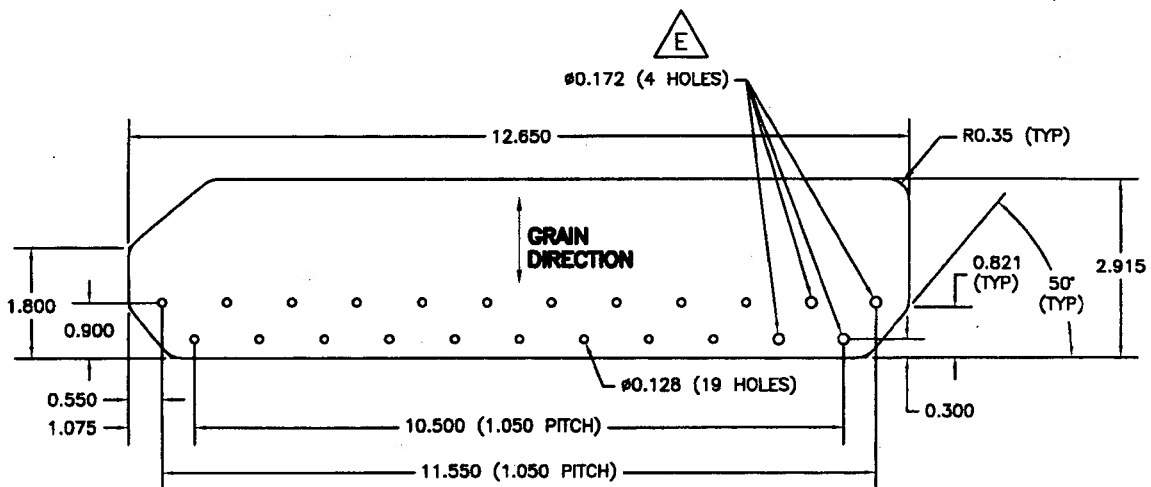
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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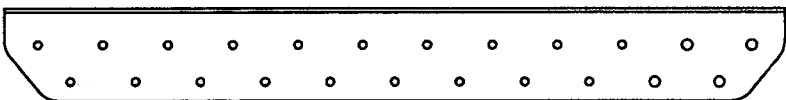
DART

061013-#

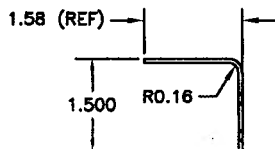
DESIGN	RF	DRAWN BY	CE	DART AEROSPACE LTD HAMKESBURT, ONTARIO, CANADA		REV. E
CHECKED	PH	APPROVED	[Signature]	DRAWING NO.	D2175	SHEET 1 OF 1
DATE	06.09.25		TITLE	ANGLE		SCALE
A		95.10.25	NEW ISSUE			
B		96.01.18	CHANGED DIMENSION			
C		00.09.11	UPDATE FINISH SPEC			
D		04.06.03	RE-DESIGN			
E		06.09.25	INC HOLE DIA TO Ø0.172, 4 HOLES			



D2175-1F FLAT PATTERN



D2175-1 BEND DETAIL SHOWN
(D2175-2 BENT OPPOSITE)



NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) ALL DIMENSIONS ARE IN INCHES

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